



Dart Aerospace Ltd.
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D2564

Job Sheet 204541



Part No: D2564

Job Qty: ~~30 pcs~~

Part Name: Mounting Angle

36 pcs. B.A.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/12/19

Job Tracking No:

Due Date: 12/30/19

Created By: Marie Lajeunesse

Type: SOLD *Stu*

Description:

Note: DWG REV B1 IPP: D 02.09.09 Re-format; Added FA276 Folio KJ/RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	30 pcs	12/30/19	12/30/19	0.00	0.75	Bandsaw - 1	B.A. 20-01-25
110	HAAS 4 Axis - B4B	30 pcs	12/30/19	12/30/19	1.00	2.00	HAAS - 1 - B4B	B.A. 20-01-25
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
130	QC 8	30 pcs	12/30/19	12/30/19	0.00	0.00	QC 8 - 12	St 20-01-27
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
							QC 8 - 57	
							QC 8 - 76	



Container No: S251096



Part: D2564

Job No: 204541

Serial No/Batch: S251096

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 01/27/20

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				QC 8 - 61	
140 Packaging 3-1 - Stock - B4B 30 pcs	12/30/19	0.00 0.00	Packaging 3 - 1 - B4B		
			Packaging 3 - 2 - B4B		
			Packaging 3 - 3 - B4B		
			Packaging 3 - 4 - B4B		
			Packaging 3 - 5 - B4B		
			Packaging 3 - 6 - B4B		
			Packaging 3 - 7 - B4B		
			Packaging 3 - 8 - B4B		
			Packaging 3 - 9 - B4B		
			Packaging 3 - 10 - B4B		
			Packaging 3 - 11 - B4B		
			Packaging 3 - 12 - B4B		
			Packaging 3 - 13 - B4B		
			Packaging 3 - 14 - B4B		
			Packaging 3 - 15 - B4B		
			Packaging 3 - 16 - B4B		
			Packaging 3 - 17 - B4B		
			Packaging 3 - 18 - B4B		
			Packaging 3 - 19 - B4B	DAS	
			Packaging 3 - 20 - B4B	43	
			Packaging 3 - 21 - B4B	9-89	
			Packaging 3 - 22 - B4B		
			Packaging 3 - 23 - B4B		
			Packaging 3 - 24 - B4B		
			Packaging 3 - 25 - B4B		
			Packaging 3 - 26 - B4B		
			Packaging 3 - 27 - B4B		
			Packaging 3 - 28 - B4B		
			Packaging 3 - 29 - B4B		
			Packaging 3 - 30 - B4B		
			Packaging 3 - 31 - B4B		
			Packaging 3 - 32 - B4B		
			Packaging 3 - 33 - B4B		
			Packaging 3 - 34 - B4B		
			Packaging 3 - 35 - B4B		
			Packaging 3 - 36 - B4B		
150 QC 21 - SA	30 pcs	12/30/19	0.00 0.00	QC 21 - SA - 21	21
				QC 21 - SA - 70	21
				QC 21 - SA - 53	21

Part Op 100 - (Bandsaw)Cut D6207 Extrusion: 1.00" Long
 Descriptions: 110 - (HAAS CNC vertical machine #1)1- Mill as per Folio FA276 Rev: ____ & Dwg D2564 Rev: B1
 130 - (QC8- Inspect parts - second check)
 140 - (Identify as per dwg & Stock Location: _____) *** STOCK IN STEP CELL ***
 150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6A1.000W.125	6061T6 Angle 1.00 X 1.00 X .125W	2.7480 ft (.0916 ea)	100-Bandsaw - 1	5123412
3.2916 ft (used)				0.4234 ft (scrap)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6A1.000W.125	3	10	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Angle	1.000inches $\pm$ 0.030	1.030 0.970		
2	Mounting Angle	0.625inches $\pm$ 0.010	0.635 0.615		
3	Mounting Angle	0.257inches $\pm$ 0.010	0.267 0.247		
4	Mounting Angle	1.000inches $\pm$ 0.010	1.010 0.990		
5	Mounting Angle	1.000inches $\pm$ 0.010	1.010 0.990		
6	Mounting Angle	0.375inches $\pm$ 0.010	0.385 0.365		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

